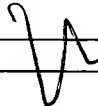


Date: Thursday, 06/12/2007 10:40:33 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D135-751-011 REWORK
Job Number : 36167	
Estimate Number : 10804	
P.O. Number : <i>NA</i>	Part Number : D135751011
This Issue : 06/12/2007 S.O. No. : <i>NA</i>	Drawing Number : ECN1036
Prsht Rev. : NC	Project Number : <i>NA</i>
First Issue : <i>NA</i> Type : LANDING GEAR	Drawing Revision : <i>NA</i>
Previous Run : 36164	Material : <i>NA</i>
Written By : 	Due Date : 24/12/2007
Checked & Approved By : _____	Qty: 1 Um: Each
Comment : _____	



Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

1 X D135-751-011 B28956

2.0	D135751011	SKIDTUBE INSTALLATION
-----	------------	-----------------------



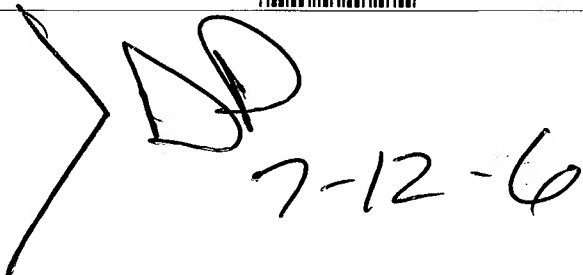
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 SKIDTUBE INSTALLATION

3.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

REMOVE 1 X D3508-7 REV.B WEARPLATE
 REMOVE 2 X D3512-1 REV.B WEARPLATE
 SCRAP BOTH
 REWORK SKID PER DRWG IAW D3507 REV.C
 (DRILLING DETAIL HAS CHANGED)



4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 06/12/2007 10:40:33 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D135-751-011 REWORK

Job Number: 36167

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

ALUMINUM ROD m 105138

WELD 2 X D3504-5 CROSSBOLT SPACERS
PER DRWG D3507 REV.C

BE 07-12-13

6.0

D35045

CROSSBOLT SPACER



Comment: Qty.: 2.0000 (s)/Unit Total: 2.0000 (s)
CROSSBOLT SPACER

2.36181

BE 07-12-13

7.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

QCC

7/12/14

QC9 7/12/14

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

REMOVE ALL EXISTING PARTS:
WEARPLATES, CAPS, INSERTS, BOLTS, WASHERS
KEEP EXISTING WEARPLATES & CAPS
DISCARD INSERTS, BOLTS & WASHERS

N/A

BE 07.12.17

MASK D3506-1/3 DOUBLER, PLUG HOLES
RE-POWDER COAT PER QSI005
(STRIP IF NECESSARY)

> FL 07/12/17 @

> m. 07/12/17 (1X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 07-12-17 @

10.0

ALS41032130

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total: 38.0000 Each(s)
Insert

N/A

BR 07/12/17 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 06/12/2007 10:40:33 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D135-751-011 REWORK

Job Number: 36167

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Insert

NA

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
RE-ASSEMBLE CAPS (SIKAFLEX) B
& WEARPLATES
PER DRWG D3507 REV.C

M 105585

EXP. DATE 08-07

BR 07-12-17

PICK NEW 1 X D3508-7 REV.C B
INSTALL PER DRWG D3507 REV.C

36179

PICK 4 X D3492-043 PLUGS B
INSTALL PER DRWG D3507 REV.C

35840

WING WALK BR 07-12-17

13.0

D3492043

PLUG ASSEMBLY



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
PLUG ASSEMBLY

B 35840

BR

14.0

D35087

WEARPLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARPLATE

B 36179

BR

15.0

AN3C4A

BOLT



Comment: Qty.: 31.0000 Each(s)/Unit Total: 31.0000 Each(s)
BOLT

M 106431

BR

16.0

AN960C10L

washer



Comment: Qty.: 33.0000 Each(s)/Unit Total: 33.0000 Each(s)
washer

M 106302

M 106575

BR

* ADD ~~GASKET~~ ~~B 35587~~
B 36001

ADD ~~GASKET~~ D 3558-7
B 36388

* ADD AFT CAP D 2965 → B 36392 BR 07-12-18
BR 07-12-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 06/12/2007 10:40:33 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D135-751-011 REWORK

Job Number: 36167

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN3C5A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Bolt *m 106557*

BL

18.0

AN526C1032R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Screw *m 15072*

BL

07-12-18 (X1)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/12/18 (X1)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
ENSURE ORIGINAL KIT IS INCLUDED
ADD:

2 X D3512-1 **REV.C** WEARPLATE B *36180*

AS 09/12/19

(X1)

21.0

D35121

WEARPLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
WEARPLATE *36180*

AS 09/12/19

(X1)

22.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/12/21 (X1)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PACKAGE PER PPP
USING NEW B/N - CHG 001

DATA 07/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 07/12/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 06/12/2007 10:40:33 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D135-751-011 REWORK

Job Number: 36167

Part Number: D135751011

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



DO 07.12.27
U 07.12.24

POSITIVE RECALL
EFFECTIVE 07.12.14 AUTH
RELEASED 07.12.14 DATE

36167

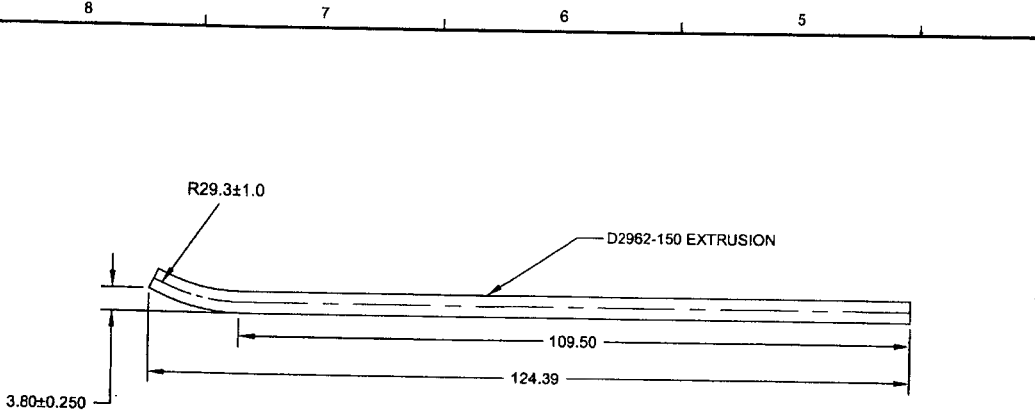
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

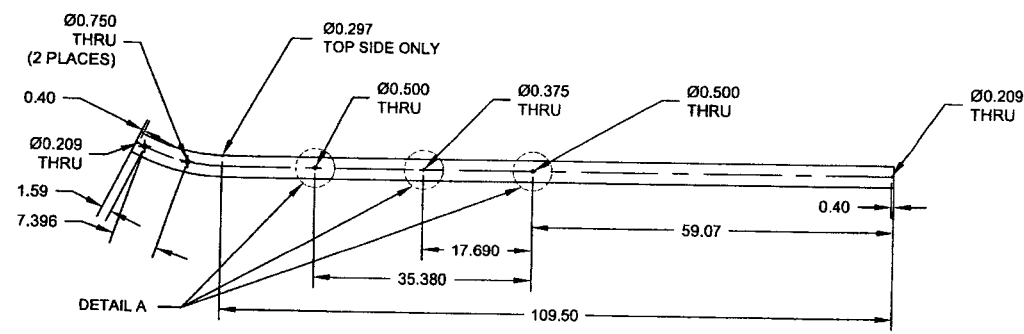
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

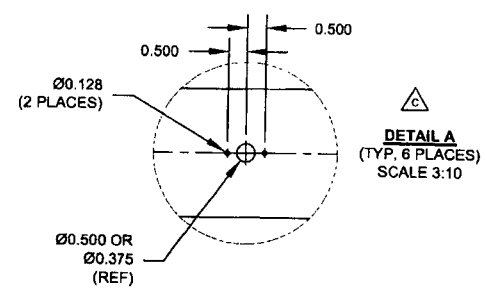
NOTE: Date & initial all entries



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



DETAIL A
(TYP. 6 PLACES)
SCALE 3:10

W 26107

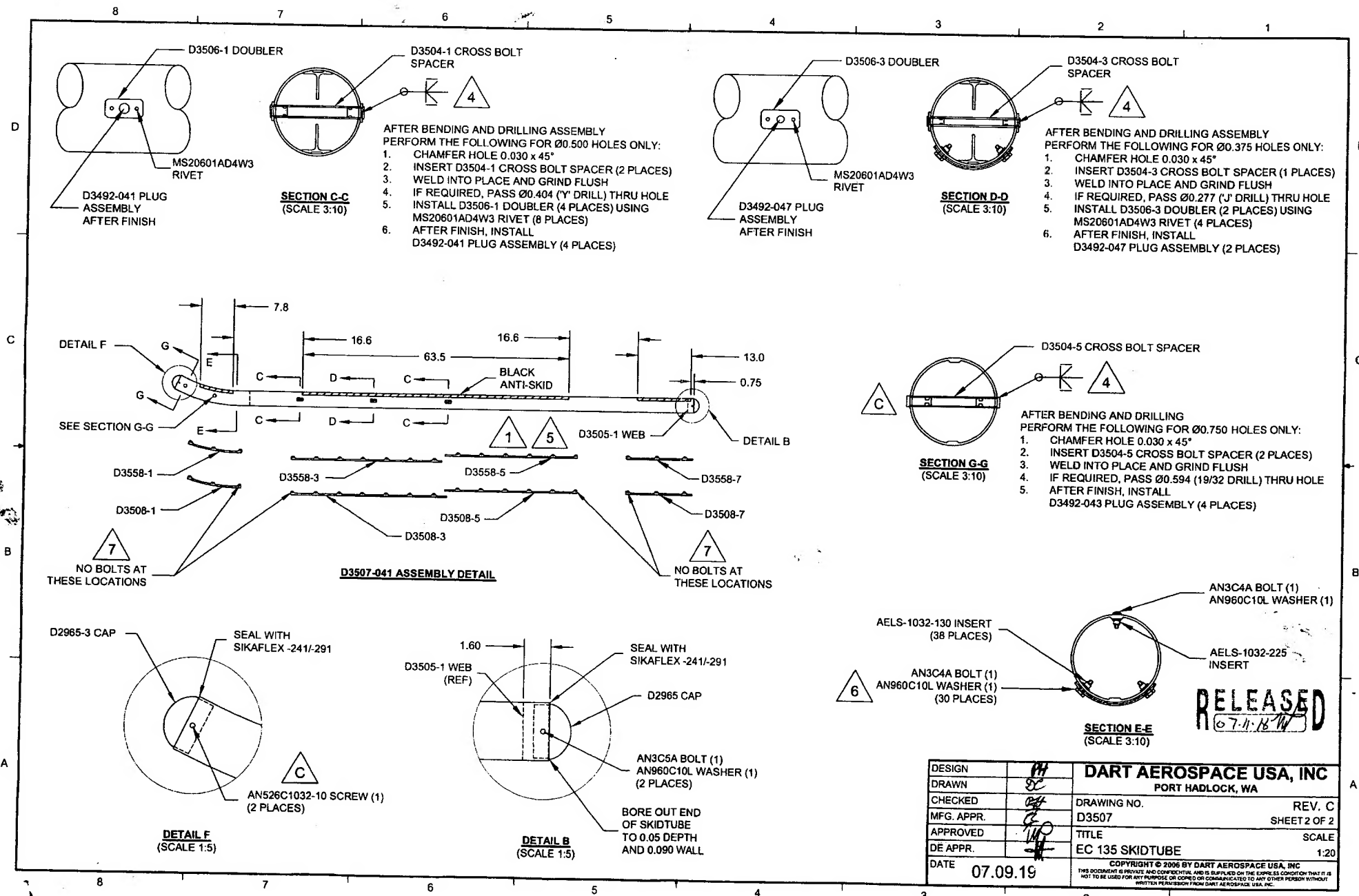
Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AEIS-1032-130	INSERT
1	AEIS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4 3.5 1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8888 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AEIS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

RELEASED
07.11.16

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR, CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	JIC		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3507	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	EC 135 SKIDTUBE	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



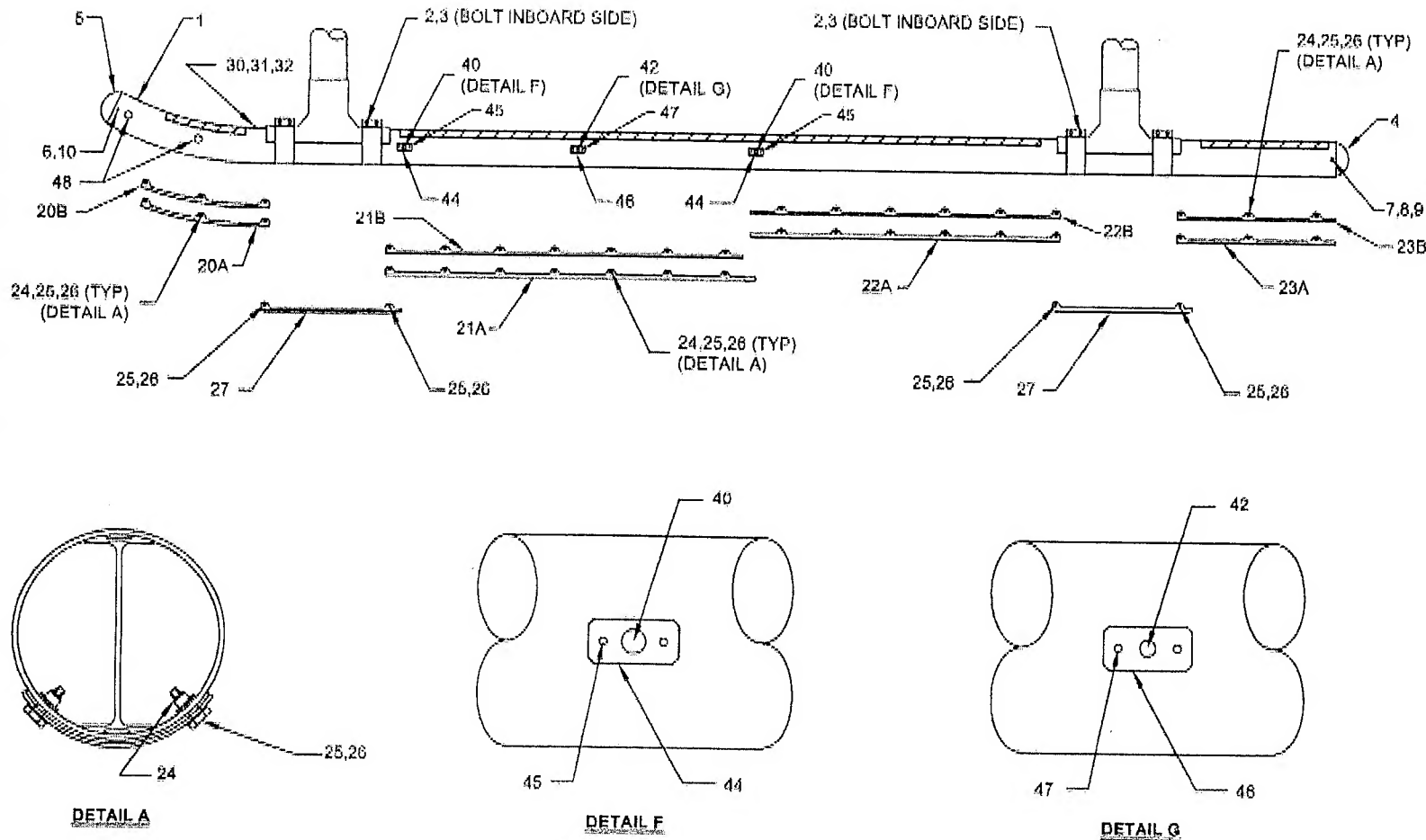


FIGURE 2 - D135-751-011 SKIDTUBE INSTALLATION

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Revision: **C**

Date: 07.09.20

Date: Friday, 11/01/2008 2:50:59 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D135-751
Job Number : 36712	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : Z_CUSTOM
This Issue : 11/01/2008 S.O. No. : NA	Drawing Number : ECN 1104
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : N/A
Previous Run : 00015	Material : N/A
Written By :	Due Date : 18/01/2008 Qty: 1 Um: Each
Checked & Approved By :	
Comment :	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE FROM STK:

2 X D135-751-011 B

 ADD NEW PAPERWORK TO KITS
 PER ECN 1104

RETURN TO STK

2.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion


 08-11-14
 U

Date: Thursday, 02/10/2008 2:26:30 PM
User: Melanie Fauteux

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : UPDATE PAPERWORK D135-751-011/041/043/101
Job Number : 42424	
Estimate Number : 10804	
P.O. Number :	Part Number : ECN10
This Issue : 02/10/2008 S.O. No. :	Drawing Number : ECN08-544
Prsht Rev. : NC	Project Number :
First Issue : / / Type : SKIDTUBES	Drawing Revision :
Previous Run : 00015	Material :
Written By :	Due Date : 02/10/2008 Qty: 1 Um: Each
Checked & Approved By : <u>MF 08-10-02</u>	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

PULL FROM STOCK D135-751-011 B 36165 X QTY1
B 36167 X QTY1

UPDATE PAPERWORK : RELEASE FAA STC SR01709SE
PER ECN08-544

RETURN TO STOCK

8/10/2 *2x 5d*

2.0	QC21	FINAL INSPECTION W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION W/O RELEASE

08/10/03

Job Completion



h 081003